

Usr

Wednesday, 11/22/2006 1:40:01 PM
Kim Johnston

Process Sheet

Split
SS 07/01/19

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 29651		
Estimate Number	: 10716		
P.O. Number	: N/A	Part Number	: D3121241
This Issue	: 11/22/2006 S.O. No. : N/A	Drawing Number	: D3121 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 27433	Material	: N/A
Written By	: <u>JA 06 11 22</u>	Due Date	: 11/29/2006
Checked & Approved By	: <u>JA 06 11 22</u>	Qty:	20 Um: Each
Comment	: Est Rev: A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDLRINR12500	DELRIN ROUND BAR 1.25"
Comment: Qty.: 0.0546 f(s)/Unit Total: 1.0920 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500) Identify as D3121-25 Batch: <u>M101527</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	D312123	Bearing
Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing <u>B26936</u>		

x18

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 29651

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

Er/07/01/18

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo7/01/18 (12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

R 7/01/19 (14)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do7/01/19 (12)

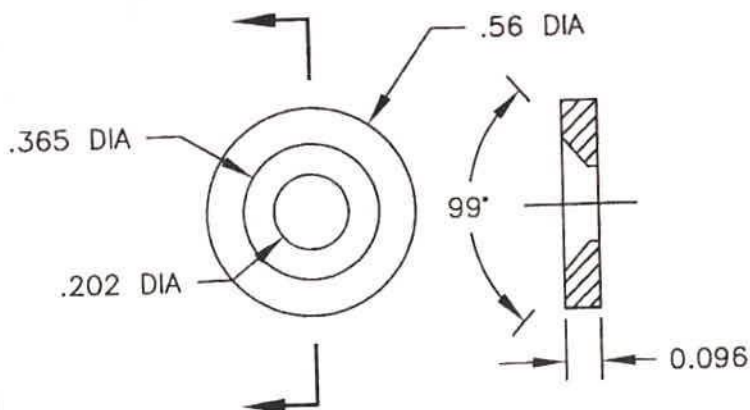
Job Completion



U 07-01-19

DART

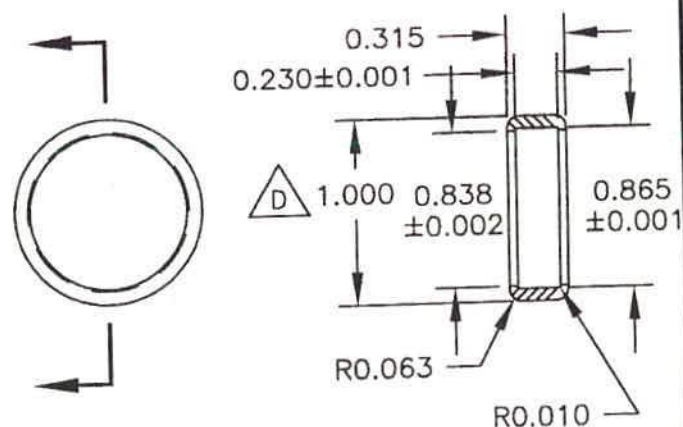
DESIGN	DRAWN BY	DART AEROSPACE LTD	
	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3121	SHEET 10 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:1

**D3121-17 WASHER (SCALE 2:1)**

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3121-21 BOLT (SCALE 1:1)

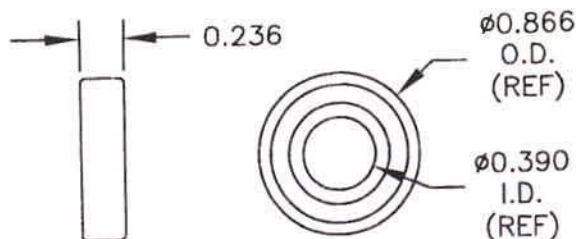
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

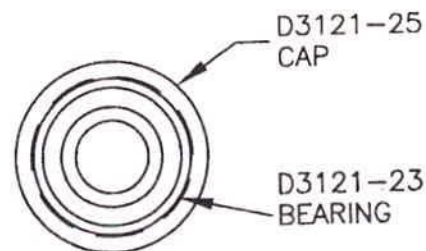
D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, $\phi 1.25$ (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

SHOPLIST
RETURN TO
RELEASED
060602
29651

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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